

# Work Order ID 70763

Wednesday, June 15, 2011 8:00:43 AM

Page 1

Item ID: D3646-3

Accept

Revision ID:

Item Name: Arm

Start Date: 6/15/2011 Start Qty: 10.00

Required Date: 6/22/2011 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date: 11-06-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3646

Rev B

100

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

1-Punch to length as per Dwg D3646 & template DT8959

SB 11/10/05

10

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr 2- Bend as per dwg D3646

SB 11/10/27

10

120

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

SB 11/10/27

(10)

# Work Order ID 70763

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Page 2

Item ID: D3646-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 6/15/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

150

Identify as per dwg & Stock Location

0.00



Packaging

Packaging

Memo

0.00

10XØM-11/10/27

10 BR 11-10-27  
COUNTED

11/10/27 100

M 117338

3200F 2:45  
3:15

229

**Work Order ID 70763**

Wednesday, June 15, 2011 8:00:43 AM



Page 3

Item ID: D3646-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm

Start Date: 6/15/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

11/10/28 

11-10-28  
(10)

# Picklist Print

Wednesday, June 15, 2011 8:00:54 AM

Page 1

Work Order ID: 70763



Parent Item: D3646-3



Parent Item Name: Arm


Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev. A new issue 07.07.25 EC verified by:JLM

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TR0.500W.035  |                        | Purchased     | No          |                     |                  | 110             | f                  | 218.7796       | 2.91        | 30.63158     |               |                |        |
|  |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |
| 304 RD Tube .500 x .035W  |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |



30 6/25

Location

Loc Qty

Loc Code

MAT017

218.779638

115535

2.33

116720

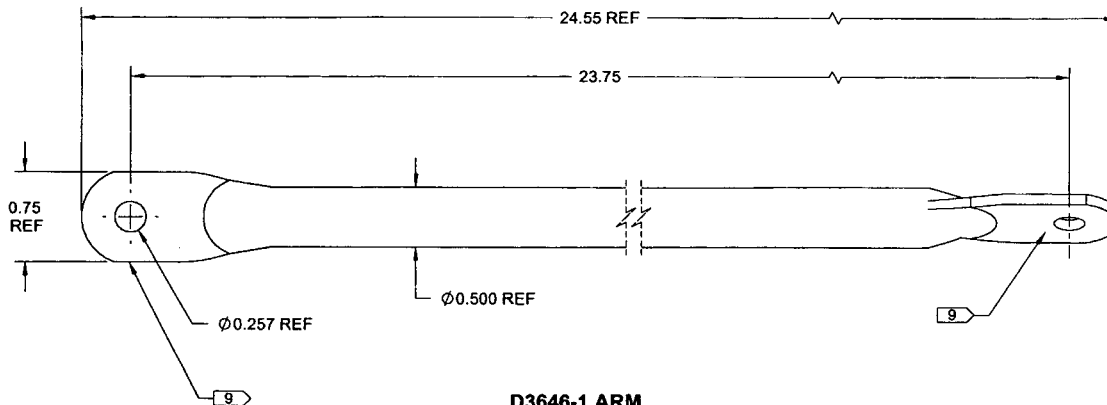
1.66068

117598

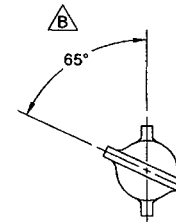
214.788958

M118702

32



**D3646-1 ARM**



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70763  
*PR 11-06-15*

**RELEASED**  
*09/06/23 M*

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS TUBE  $\phi 0.500 \times 0.035$  WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.38 lbs
- 8) MAKE PER TEMPLATE DT8958
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

|            |   |    |          |
|------------|---|----|----------|
| B          | REFORMAT DWG, ANGLE 65° WAS 45° (ZN C3-1), ADD IDENTIFICATION TAG (ZN A8-1, A8-2) | CP | 09.06.04 |
| A          | NEW ISSUE   | MB | 07.06.06 |
| REV.       | DESCRIPTION   | BY | DATE     |
| DESIGN     |   |    |          |
| DRAWN      |   |    |          |
| CHECKED    |   |    |          |
| MFG. APPR. |   |    |          |
| APPROVED   |   |    |          |
| DE APPR.   |   |    |          |
| DATE       | 09.06.04  |    |          |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3646** REV. B  
TITLE **ARM** SCALE NTS

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